

What is claimed is:

1. A tampon having an introduction end and an opposite withdrawal end, the tampon comprising a compressed absorbent structure, which structure comprises:

- an absorbent material having a length, a width defined from a first  
5 edge corresponding to the introduction end of the tampon to a second edge  
corresponding to the withdrawal end of the tampon, and a thickness; and
- an overwrap material disposed on the absorbent material, wherein  
the overwrap material has a length greater than the length of the absorbent  
material and a width generally corresponding to the width of the absorbent  
10 material and comprises a liquid-permeable zone and a liquid-resistant zone;  
and wherein the liquid-resistant zone of the overwrap material forms a fold  
over the second edge of the absorbent material.

2. The tampon of claim 1 wherein the absorbent material comprises a  
15 fibrous web.

3. The tampon of claim 1 wherein the overwrap material comprises a  
nonwoven fibrous web.

20 4. The tampon of claim 1 wherein the overwrap material comprises at least  
two webs joined together between the fold and the first edge of the absorbent  
material.

25 5. The tampon of claim 4 wherein a first web is a nonwoven web that forms  
the liquid-permeable zone.

6. The tampon of claim 4 wherein a first web is an apertured film that forms the liquid-permeable zone.

7. The tampon of claim 4 wherein a second web is a nonwoven web that  
5 forms the liquid-impermeable zone.

8. The tampon of claim 7 wherein the nonwoven web is treated to be liquid-impermeable.

9. The tampon of claim 4 wherein a second web is a polymeric film that  
10 forms the liquid-impermeable zone.

10. The tampon of claim 1 wherein the overwrap material comprises a plastic film.  
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11. The tampon of claim 1 wherein the length of the absorbent material is greater than its width.

12. The tampon of claim 11 wherein the tampon comprises a spirally wound,  
20 compressed absorbent structure.

13. The tampon of claim 1 wherein the overwrap material has a width, measured parallel to the width of the absorbent material, generally corresponding to the width of the absorbent material.  
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14. The tampon of claim 13 wherein the width of the overwrap material is not less than the width of the absorbent material.

15. The tampon of claim 13 wherein the liquid-resistant zone comprises a liquid-impermeable structure.

5           16. A method of forming a tampon having an introduction end and an opposite withdrawal end, the method comprising the steps of:

                  - attaching a length of overwrap material having a liquid-permeable zone and a liquid-resistant zone to an absorbent material to form a laminate, the absorbent material having a length, a width defined from a first edge  
10               corresponding to the introduction end of the tampon to a second edge corresponding to the withdrawal end of the tampon;

                  - folding a portion of the liquid-resistant zone over the second edge of the absorbent material; and

                  - forming the laminate into a tampon, wherein the folded portion of  
15               the liquid-resistant zone of the overwrap material is located at the withdrawal end of the tampon.

17. The method of claim 16 wherein the step of attaching comprises thermobonding.

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18. The method of claim 16 wherein the step of attaching comprises adhesive bonding.

19. The method of claim 16 wherein the overwrap material comprises at  
25               least two webs joined together between the fold and the first edge of the absorbent material.

20. The tampon of claim 19 wherein a first web is a nonwoven web that forms the liquid-permeable zone.

21. The tampon of claim 19 wherein a first web is an apertured film that  
5 forms the liquid-permeable zone.

22. The tampon of claim 19 wherein a second web is a nonwoven web that forms the liquid-impermeable zone.

10 23. The tampon of claim 22 wherein the nonwoven web is treated to be liquid-impermeable.

24. The tampon of claim 19 wherein a second web is a polymeric film that forms the liquid-impermeable zone.

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25. A method of forming a tampon having an introduction end and an opposite withdrawal end, the method comprising the steps of:

- attaching a plurality of spaced-apart, individual absorbent material web pads to a substantially continuous web of overwrap material having a  
20 length, a liquid-permeable zone and a liquid-resistant zone to form a laminate, each individual absorbent material web pad having a length oriented parallel to the substantially continuous length of overwrap material, a width defined from a first edge corresponding to the introduction end of the tampon to a second edge corresponding to the withdrawal end of the tampon;
- 25 - folding a portion of the liquid-resistant zone over the second edge of the individual absorbent material web pads;

- separating a construction comprising one individual absorbent material web pad and a section of the overwrap material from the laminate, the construction having a tab formed of an extension of the overwrap material beyond a longitudinal end of the individual absorbent material web pad;

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- looping a withdrawal string around an intermediate portion of the construction, generally parallel to the width of the individual absorbent material web pad;

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- winding the construction about an axis parallel to the width of the individual absorbent material web pad to form a substantially cylindrical tampon blank, with the withdrawal string extending from the withdrawal end of the tampon blank;

- attaching the tab to a portion of the overwrap material disposed on the surface of the tampon blank; and

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- forming the tampon blank into a tampon.

26. The method of claim 25 further comprising providing separation lines substantially perpendicular to the length of the substantially continuous web of overwrap material between the individual absorbent material web pads.

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27. The method of claim 26 wherein the step of providing separation lines comprises perforating the overwrap material between the individual absorbent material web pads.

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28. The method of claim 26 wherein the step of providing separation lines comprises thinning the overwrap material between the individual absorbent material web pads.

29. The method of either of claims 27 or 28 wherein the step of separating the construction comprises stretching the overwrap material in the vicinity of at least one separation line.

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30. The method of claim 25 wherein the step of separating the construction comprises severing the overwrap material between the individual absorbent material web pads.

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31. The method of claim 25 wherein the steps of attaching comprise thermobonding.

32. The method of claim 25 wherein the steps of attaching comprise adhesive bonding.

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33. The method of claim 25 wherein the step of forming the tampon blank into a tampon comprises compressing the tampon blank.

34. The method of claim 25 wherein the overwrap material comprises at least two webs joined together between the fold and the first edge of the absorbent material.

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35. The tampon of claim 34 wherein a first web is a nonwoven web that forms the liquid-permeable zone.

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36. The tampon of claim 34 wherein a first web is an apertured film that forms the liquid-permeable zone.

37. The tampon of claim 34 wherein a second web is a nonwoven web that forms the liquid-impermeable zone.

5           38. The tampon of claim 37 wherein the nonwoven web is treated to be liquid-impermeable.

39. The tampon of claim 34 wherein a second web is a polymeric film that forms the liquid-impermeable zone.

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